

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003471**Date Inspected:** 29-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Chen Chih-Ming/Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG side, bottom and deck panels**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA observed ZPMC qualified welding personnel SAW on SEG-027B-002 (SP-121-001 to SP-148-001) following the guide lines of WPS-B-T-2221-B-L2c-S-2. QC monitored the welding process continuously throughout the evening. The welder ID and welding parameters as measured with Quality Controls calibrated instruments appeared to be in conformance with the posted WPS's and were as follows:

Volts: 31 Amps: 578 Travel speed: 495mm/min

Welder ID: 045265

QA performed 10% verification Ultrasonic Testing (UT) on the following weld joints: SEG-18B-001, 009 and 002 (R1 repairs)// SEG-18C-008, 009 and 001 (R1 repairs) // SEG-017B-017 and 018 // SEG-017C-016, 017 and 019. All of the above mentioned welds appeared to conform to AWS D1.5 2002 and the contract documents.

QA noted that ZPMC UT technicians have UT'ed and rejected the following joints: SEG-018B-008 (R1 repairs) // SEG-018C-002 (R1 repairs) // SEG-014A-015 and 016 (R1 repairs) // SEG-017B-004, 019, 003 and 016 // SEG-017C-003, 018 and 004.

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Other general observations include ZPMC personnel fitting and welding OBG east fixture, OBG temporary support columns, grinding and weld bevel prep on various OBG components.

Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
